



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Scph 7889

D3910-3
Job Sheet 167536



Part No: D3910-3

Job Qty: 40 ea

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/2/17

Job Tracking No:

Due Date: 11/17/17

Created By: Chantal Lavoie

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Signoff
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	11/16/17	11/16/17	0.00	0.00	Start up container		me
110	Purchasing	40 pcs	11/16/17	11/16/17	0.00	0.00	Purchasing		
120	Packaging	40 pcs	11/16/17	11/16/17	0.00	0.00	Packaging2		sp. DAS 38 9-88
130	QC	40 pcs	11/16/17	11/16/17	0.00	0.00	QC6		
140	HandFinish	40 pcs	11/16/17	11/16/17	0.00	0.61	HandFinish1		
150	QC	40 pcs	11/16/17	11/16/17	0.00	0.00	QC7		
160	Powdercoat	40 pcs	11/17/17	11/17/17	0.00	0.35	Powdercoat1		DAS 38 9-88
170	QC	40 pcs	11/17/17	11/17/17	0.00	0.00	QC3		
180	Packaging	40 pcs	11/17/17	11/17/17	0.00	0.00	Packaging3		
190	QC21-SA	40 Ea	11/17/17	11/17/17	0.00	0.00	QC21		

Part Op 110 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005

Descriptions: 120 - Ensure C of C is attach

160 - START TIME: _____

ST523

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2423 S007768	5	471	0	0
	D3910-3P S007733	40	0	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches $\pm$ 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches $\pm$ 0.030	1.410 1.350		
3	Crosstube Lug	0.080Inches $\pm$ 0.020	0.100 0.060	Radius	
4	Crosstube Lug	0.270Inches $\pm$ 0.030	0.300 0.240	reference	
5	Crosstube Lug	0.310Inches $\pm$ 0.030	0.340 0.280		
6	Crosstube Lug	0.735Inches $\pm$ 0.010	0.745 0.725	reference	
7	Crosstube Lug	1.200Inches $\pm$ 0.030	1.230 1.170	Radius	

8	Crosstube Lug	3.700Inches $\pm$ 0.010	3.710 3.690	
9	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365	
10	Crosstube Lug	0.625Inches $\pm$ 0.010	0.635 0.615	
11	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365	
12	Crosstube Lug	0.340Inches $\pm$ 0.030	0.370 0.310	Radius
13	Crosstube Lug	0.257Inches $\pm$ 0.006 - 0.001	0.263 0.256	Diameter
14	Crosstube Lug	0.100Inches $\pm$ 0.010	0.110 0.090	
15	Crosstube Lug	45.000Degrees $\pm$ 0.500	45.500 44.500	angle
16	Crosstube Lug	1.410Inches $\pm$ 0.030	1.440 1.380	Reference

Plex 11/2/17 9:24 AM DART.LAVOIE.CHANTAL

DART
AEROSPACE
S007889

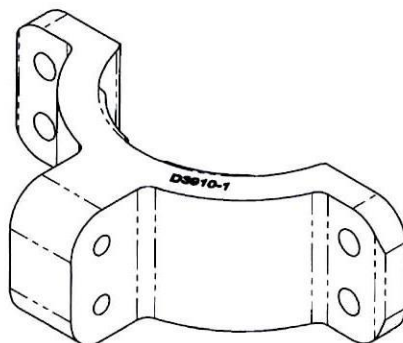
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



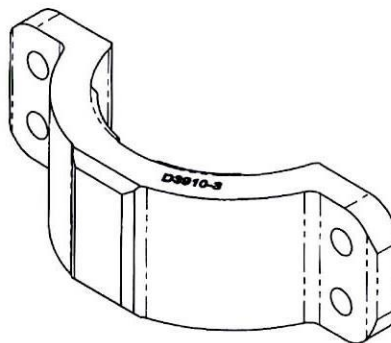
Crosstube Lug

PART NO: D3910-3
Revision:
Operation: Packaging
Change No:

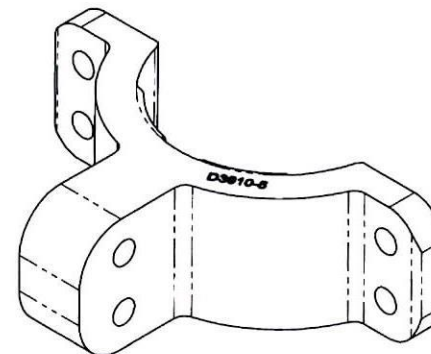
Mfg Date: 11/08/17
Job No: 167536



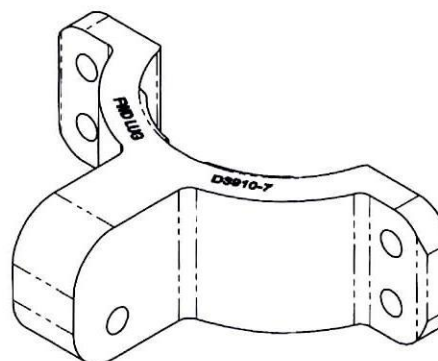
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005

RELEASED

2014 JUN 05

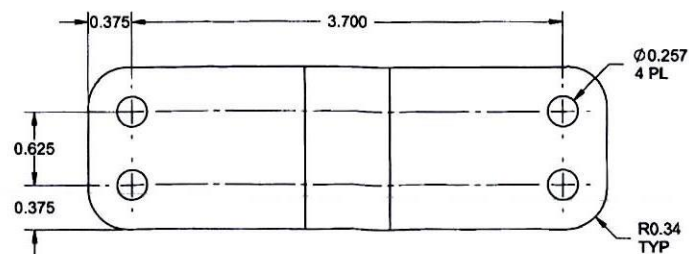
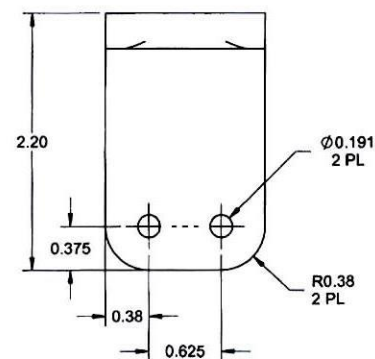
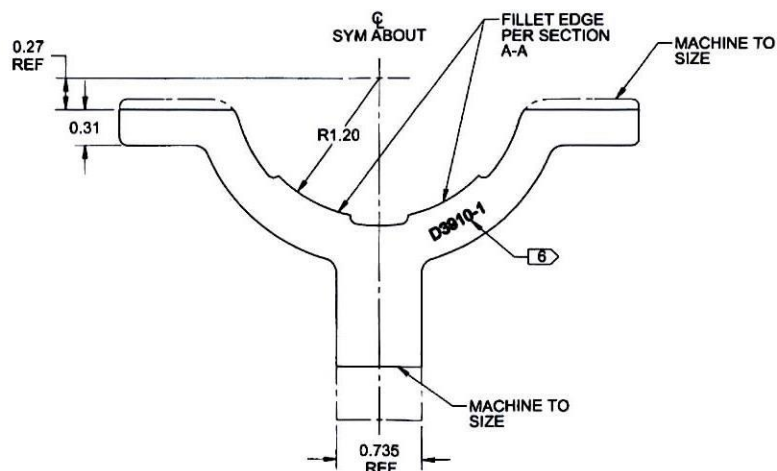
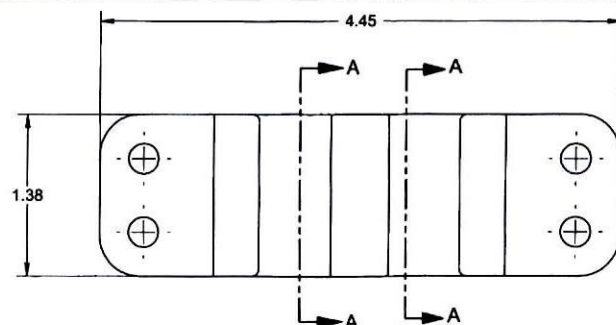
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG

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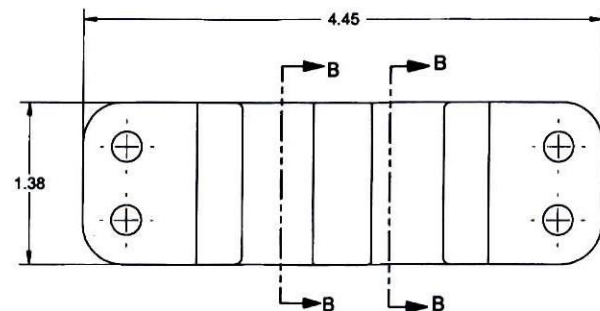
2014 JUN 05 *CP*

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B



0.27
REF

0.31

SYM ABOUT

R1.20

FILLET EDGE
PER SECTION
B-B

MACHINE TO
SIZE

D3910-3

B

MACHINE TO
SIZE

0.735
REF

0.375

0.625

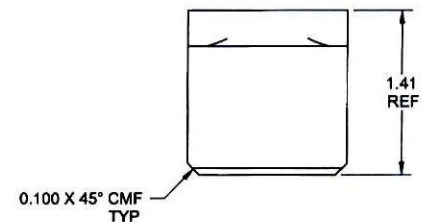
0.375

3.700

Ø0.257
4 PL

R0.34
TYP

D3910-3 X-TUBE LUG



RELEASED

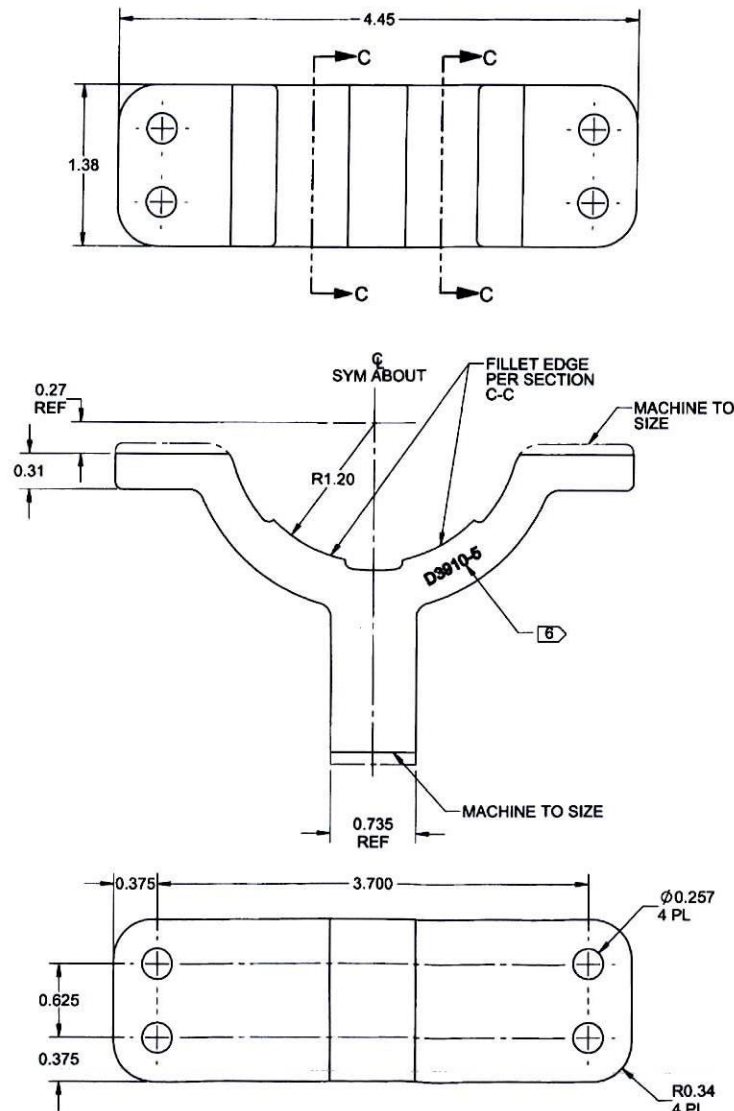
2014 JUN 05

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	DRAWING NO.	REV. E
MFG. APPR.	[Signature]	D3910	SHEET 3 OF 5
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	X-TUBE LUG (350)	NTS
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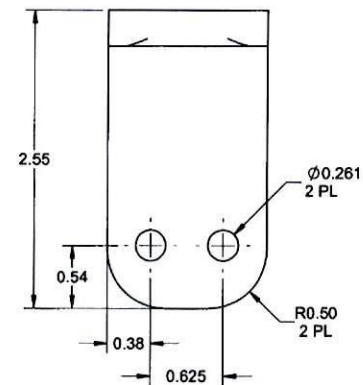
SECTION C-C



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-5 X-TUBE LUG



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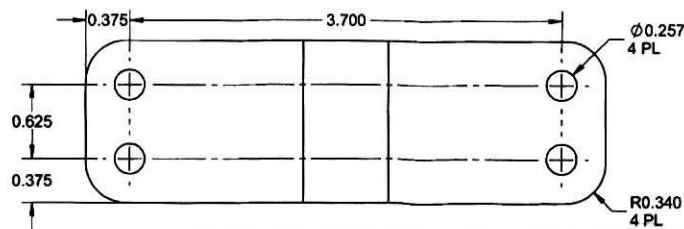
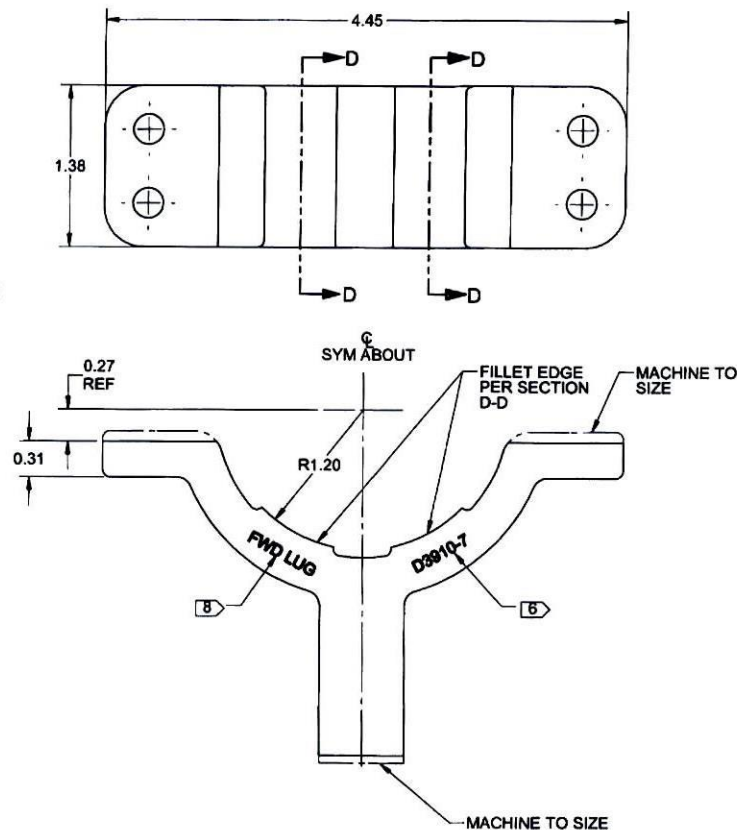
2014 JUN 05

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MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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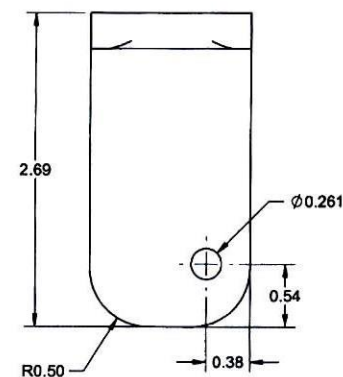
SECTION D-D



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-7 X-TUBE LUG



RELEASED

2014 JUN 05 *qf*

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3910	REV. E
MFG. APPR.		SHEET 5 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	
DATE	14.05.16	NTS	
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Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038228

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038228

PO Date: 11/2/17

Due Date: 11/23/17

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: Note: alodine and paint as per QSI 005

REVISED

Items													
Line Item	Part	Rev	Supplier Part No	Item No	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D2230-1P	-			Lug As per Dwg D2230 Rev. G		Firmed	11/23/17	160 Ea	0 Ea	160 Ea	\$12.88/Ea	\$2,060.80
Line Item Note job# 167531													
2	D2230-3P	-			Lug As Per Dwg D2230 Rev. G		Firmed	11/23/17	210 pcs	0 pcs	210 pcs	\$14.00/pcs	\$2,940.00
Line Item Note job# 167532													
3	D3235-1P	-			Lug As Per Dwg D3235 Rev. A		Firmed	11/23/17	150 pcs	0 pcs	150 pcs	\$15.00/pcs	\$2,250.00
Line Item Note job# 167533													
4	D3910-1P	-			Crosstube Lug As Per Dwg D3910 Rev. E		Firmed	11/23/17	30 Ea	0 Ea	30 Ea	\$12.88/Ea	\$386.40
Line Item Note job# 167535													
5	D3910-3P	-			Crosstube Lug As Per Dwg D3910 Rev. E		Firmed	11/23/17	40 pcs	0 pcs	40 pcs	\$13.00/pcs	\$520.00
Line Item Note job# 167536													
6	D3910-5P	-			Crosstube Lug As per Dwg D3910 Rev. E		Firmed	11/23/17	30 Ea	0 Ea	30 Ea	\$12.88/Ea	\$386.40
Line Item Note job# 167537													
7		-					Firmed	11/23/17	20 Ea	0 Ea	20 Ea	\$12.88/Ea	\$257.60

20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 22195
Date: Nov 06, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO038228 NC	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Nov 06, 2017

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
D2230-1 Mounting Lug Alodine and Paint as per QSI 005		Each	200	160	40
D2230-3 Mounting Lug Alodine and Paint as per QSI 005		Each	300	210	90
D3235-1 Mounting Lug Alodine and Paint as per QSI 005		Each	160	150	10
D3910-1 Crosstube Lug Alodine and Paint as per QSI 005		Each	30		30
D3910-3 Crosstube Lug Alodine and Paint as per QSI 005		Each	40	40	
D3910-5 Crosstube Lug Alodine and Paint as per QSI 005		Each	30	30	
D3910-7 Crosstube Lug, as per drawing D3910 Rev.E Alodine and Paint as per QSI 005		Each	20	20	
D4091-1 Lug as per drawing D4091 Rev.A Alodine and Paint as per QSI 005		Each	30	30	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					

Received by

 17-11-8

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Material Batch #	Paint Batch #	P.O. Number
22	D2230-1	Lug	148835	21012	038228
78	D2230-1	Lug	148835	20902	038228
60	D2230-1	Lug	115529	21143	038228
210	D2230-3	Lug	160522	21182	038228
150	D3235-1	Lug	148835	21003	038228
✓ 40	D3910-3	Lug	160522	21207	038228
30	D3910-5	Lug	148835	20715	038228
20	D3910-7	Lug	131451	20366	038228
30	D4091-1	Lug	148835	21095	038228

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, November 6, 2017